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D2353
Job Sheet 211688



Part No: D2353

Job Qty: 6 pcs

DAS
21
9-89

Part Name: Stiffener



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 7/24/20

Job Tracking No:

Created By: Marie Lajeunesse

Due Date: 8/24/20

Description:

Note: DWG REV C IPP Rev: A Removed from 9 Digit 05-11-10 EC IPP: B 06.11.15 waterjet EC IPP: c 06.12.07 ecn 836 ec

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	6 pcs		8/22/20	0.17	0.37	Waterjet - Flow		on 20/08/08
120	QC 8	6 pcs		8/22/20	0.00	0.00	QC 8 - 12		
							QC 8 - 14		
							QC 8 - 17		
							QC 8 - 20		
							QC 8 - 25		
							QC 8 - 3		
							QC 8 - 32		
							QC 8 - 33		
							QC 8 - 35		
							QC 8 - 39		
							QC 8 - 4		
							QC 8 - 44		
							QC 8 - 45		
							QC 8 - 49		
							QC 8 - 58		
							QC 8 - 8		
							QC 8 - 9		
							QC 8 - 68		
							QC 8 - 67		
							QC 8 - 1 (A)		
							QC 8 - 47		
							QC 8 - 40		
							QC 8 - 52		
							QC 8 - 23		
							QC 8 - 57		
							QC 8 - 76		
							QC 8 - 61		
							QC 8 - 66		
							QC 8 - 73		

DAS
AUG 06 2020 40
9-89

				QC 8 - 82	
130 Small Fab - Brake NC - B4B	6 pcs	8/22/20	0.25 0.23	Small Fab - Brake - 1 - B4B	
				Small Fab - Brake - 2 - B4B	
				Small Fab - Brake - 3 - B4B	AUG 11 2020
140 QC 5	6 pcs	8/22/20	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
				QC 5 - 61	
				QC 5 - 81	
				QC 5 - 82	
150 Handfinish - 1-1 Chemical-B4B	6 pcs	8/22/20	0.00 0.25	Handfinish - 1 - 1 - B4B	
				Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	
				Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	
155 QC 7	6 pcs	8/22/20	0.00 0.00	QC 7 - 10	
				QC 7 - 13	
				QC 7 - 14	
				QC 7 - 15	
				QC 7 - 17	
				QC 7 - 18	
				QC 7 - 19	
				QC 7 - 2	
				QC 7 - 28	
				QC 7 - 3	
				QC 7 - 30	

						QC 7 - 34	20-08-13	DAS 9-89
						QC 7 - 36		
						QC 7 - 37		
						QC 7 - 41		
						QC 7 - 47		
						QC 7 - 48		
						QC 7 - 51		
						QC 7 - 58		
						QC 7 - 59		
						QC 7 - 60		
						QC 7 - 9		
						QC 7 - 68		
						QC 7 - 50		
						QC 7 - 67		
						QC 7 - 40		
						QC 7 - 24		
						QC 7 - 43		
						QC 7 - 61		
						QC 7 - 81		
						QC 7 - 76		
						QC 7 - 79		
						QC 7 - 83		
						QC 7 - 82		
						QC 7 - 87		
160	Powdercoat - 4 Black Sand - B4B	6 pcs	8/24/20	0.00	0.09	Powdercoat - 1 - B4B		
						Powdercoat - 2 - B4B		
						Powdercoat - 3 - B4B	20-08-13	DAS 9-89
						Powdercoat - 4 - B4B		
						Powdercoat - 5 - B4B		
						Powdercoat - 6 - B4B		
						Powdercoat - 7 - B4B		
						Powdercoat - 8 - B4B		
						Powdercoat - 9 - B4B		
						Powdercoat - 10 - B4B		
170	QC 3	6 pcs	8/24/20	0.00	0.00	QC 3 - 10		
						QC 3 - 13		
						QC 3 - 15		
						QC 3 - 17		
						QC 3 - 18		
						QC 3 - 2		
						QC 3 - 28		
						QC 3 - 3		
						QC 3 - 30		
						QC 3 - 34		
						QC 3 - 36		
						QC 3 - 41		
						QC 3 - 51		
						QC 3 - 58		
						QC 3 - 59		
						QC 3 - 68		
						QC 3 - 9		
						QC 3 - 40	AUG 1 4 2020	DAS 40
						QC 3 - 19		9-89
						QC 3 - 43		
						QC 3 - 24		
						QC 3 - 61		
						QC 3 - 81		
						QC 3 - 82		
						QC 3 - 87		

180 Packaging 3-1 - Stock - B4B <i>pcs</i> <i>10 pcs mko</i>	8/24/20	0.00 0.00	Packaging 3 - 1 - B4B	
			Packaging 3 - 2 - B4B	
			Packaging 3 - 3 - B4B	
			Packaging 3 - 4 - B4B	
			Packaging 3 - 5 - B4B	DAS
			Packaging 3 - 6 - B4B	28
			Packaging 3 - 7 - B4B	9-89
			Packaging 3 - 8 - B4B	
			Packaging 3 - 9 - B4B	
			Packaging 3 - 10 - B4B	AUG 14 2020
			Packaging 3 - 11 - B4B	
			Packaging 3 - 12 - B4B	
			Packaging 3 - 13 - B4B	
			Packaging 3 - 14 - B4B	
			Packaging 3 - 15 - B4B	
			Packaging 3 - 16 - B4B	
			Packaging 3 - 17 - B4B	
			Packaging 3 - 18 - B4B	
			Packaging 3 - 19 - B4B	
			Packaging 3 - 20 - B4B	
			Packaging 3 - 21 - B4B	
			Packaging 3 - 22 - B4B	
			Packaging 3 - 23 - B4B	
			Packaging 3 - 24 - B4B	
			Packaging 3 - 25 - B4B	
			Packaging 3 - 26 - B4B	
			Packaging 3 - 27 - B4B	
			Packaging 3 - 28 - B4B	
			Packaging 3 - 29 - B4B	
			Packaging 3 - 30 - B4B	
			Packaging 3 - 31 - B4B	
			Packaging 3 - 32 - B4B	
			Packaging 3 - 33 - B4B	
			Packaging 3 - 34 - B4B	
			Packaging 3 - 35 - B4B	
			Packaging 3 - 36 - B4B	
			Packaging 3 - 37 - B4B	
190 QC 21 - SA <i>6 pcs</i>	8/24/20	0.00 0.00	QC 21 - SA - 21	DAS AUG 14 2020
			QC 21 - SA - 70	21
			QC 21 - SA - 9	9-89
			QC 21 - SA - 77	

Part Op 100 - 1-Cut as per Dwg D2353

Descriptions: 120 - (QC8- Inspect parts - second check)

130 - (Form as per dwg) Bend per Dwg D2353

140 - (QC5- Inspect part completeness to step on W/O)

150 - (Chemical Conversion Coat per QSI005 4.1)

155 - (QC7-Inspect Chemical Conversion Coat)

160 - (Black Sandtex(Ref:4.3.5.7) per QSI005 4.3) START TIME: _____

170 - (QC3- Inspect Part Finish)

180 - (Identify as per dwg & Stock Location: _____)

190 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M2024T3S.050	2024-T3 .050 Sheet	.8778 sf (.1463 ea)	100-Waterjet - Flow - 1	S237392

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	M2024T3S.050	1	75	0

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Stiffener	15.198Inches $\pm$ 0.010	15.208 15.188		15.199
2	Stiffener	0.966Inches $\pm$ 0.005	0.971 0.961		.966
3	Stiffener	0.354Inches $\pm$ 0.010	0.364 0.344		.354
4	Stiffener	0.128Inches + 0.005 - 0.000	0.133 0.128		.129

Plex 7/24/20 7:56 AM Dart.lajeunesse.marie

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor		
			QC / QA Coordinator		
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details: _____					



Container No: S291848



Part: D2353

Job No: 211688

Serial No/Batch: S291848

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

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